

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019649**Date Inspected:** 30-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Mr. Liu Yang
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #14

This QA Inspector observed the following work in progress

Orthotropic Box Girder (OBG)

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint # 125 as per WRR no. B-WR 18318, located on OBG Component, Floor beam to stiffener at Side plate of Segment 13BW, SEG 3014C. Welder is identified as 045204. ZPMC Quality Control (QC) Inspector is identified as Zhu Lin. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW -3G (3F) - FCM-Repair.

Weld joint # 028, located on OBG Component, Floor beam to Edge plate of Segment 13AW, P.P 117.5, SEG 3013R. Welder is identified as 067183. ZPMC Quality Control (QC) Inspector is identified as Liu Fang. The welding variables recorded by QC appeared to comply with the WPS – B – P -2214 – TC-U4B-FCM-1.

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Weld joint # 024, located on OBG Component, Floor beam to Edge plate of Segment 13AW, SEG 3013AH. Welder is identified as 037778. ZPMC Quality Control (QC) Inspector is identified as Liu Fang. The welding variables recorded by QC appeared to comply with the WPS – B –P -2214 –TC-U4B-FCM-1.

Weld joint # 027, located on OBG Component, Floor beam to Edge plate of Segment 13AW, SEG 3013AH. Welder is identified as 069841. ZPMC Quality Control (QC) Inspector is identified as Liu Fang. The welding variables recorded by QC appeared to comply with the WPS – B –P -2214 –TC-U4B-FCM-1.

Repair welding of Weld joint # 067 as per CWR no. B-CWR 2582, located on OBG Component, Deck plate of Segment 13CW, DP 3152-001. Welder is identified as 037779. ZPMC Quality Control (QC) Inspector is identified as Shao Jian Yuan. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) - FCM-Repair.

Repair welding of Weld joint # 119 as per CWR no. B-CWR 2586, located on OBG Component, Deck plate of Segment 13CW, DP 3152-001. Welder is identified as 037780. ZPMC Quality Control (QC) Inspector is identified as Shao Jian Yuan. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) - FCM-Repair.

Flux cored Arc welding (FCAW)

Weld joint # 168, located on OBG Component, Floor beam to I Rib stiffener in side plate of of Segment 13AW, SEG 3013P. Welder is identified as 201583. ZPMC Quality Control (QC) Inspector is identified as Liu Fang. The welding variables recorded by QC appeared to comply with the WPS – B-T-2233 -Esab.

Weld joint # 187, located on OBG Component, Floor beam to I Rib stiffener in side plate of of Segment 13AW, SEG 3013P. Welder is identified as 045143. ZPMC Quality Control (QC) Inspector is identified as Liu Fang. The welding variables recorded by QC appeared to comply with the WPS – B-T-2232 -Esab.

Weld joint # 037, located on OBG Component, Sub assembly plate to Bottom plate of of Segment 14W, SEG 3020BB. Welder is identified as 068445. ZPMC Quality Control (QC) Inspector is identified as Liu Fang. The welding variables recorded by QC appeared to comply with the WPS – B-T-2232 -Esab.

Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 07990

This QA inspector performed (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an TL 6028 MT report for this date. The member is identified as OBG components. The weld designations reviewed are as follows:

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AP3031-Jt. nos - 246, 247, 254, 260, 261, 270, 282, 290, 288, 291, 323, 338, 339, 385, 434, 468, 483,
528, 529, 576, 577, 611, 627, 659, 673, 720, 723, 768, 769, 816, 801, 817, 860, 863,
906, 909, 954, 995, 985, 998

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer